



Dart Aerospace Ltd.
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RBT400313
Job Sheet 173353



Part No: RBT400313

Job Qty: 1 ea

Part Name: Main Transmission Backlash Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400313 Rev 1 IPP Rev A 18.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		4/28/18	0.00	0.00	Start Up Small Fab-2		MU
110	Small Fab	1 pcs		4/30/18	0.00	1.00	Small Fab-3		MU DAS
120	QC	1 pcs		4/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		4/30/18	0.00	0.00	Packaging3-1		MU 389
140	QC21-SA	1 Ea		4/30/18	0.00	0.00	QC21		DAS 21 3-89

Part Op
Descriptions: 110 - 1-Assemble as per DWG sheet 1

JUL 2 5 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90145A471	Dowel Pin	1 Ea (1 ea)	90-Start up Operation	5048599
95462A033	Hex Nut	1 Ea (1 ea)	90-Start up Operation	5048595
98296A883	Spring Pin 1/8" X 1"	1 (1 ea)	90-Start up Operation	5048596
RBT400313-1	Adapter Weldment	1 (1 ea)	90-Start up Operation	5069666
RBT400313-7	Bolt	1 Ea (1 ea)	90-Start up Operation	5075026
RBT400313-9	Shoe	1 Ea (1 ea)	90-Start up Operation	5068793

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90145A471	1	0	0
	95462A033	1	0	0
	98296A883	1	0	0
	RBT400313-1	1	0	0
	RBT400313-7	1	0	0
	RBT400313-9	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



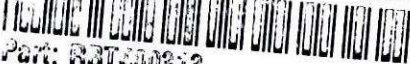
QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date: _____	Step #: _____	QTY Effective: _____				MRB (QS1042) Approval					
Description of Non-Conformance											
Disposition											
Completed By _____											
Lead hand / Supervisor Approval Verification _____											
QC / QA Coordinator Approval _____											
Date: 07/24/18											
Root Cause											
Environment ☐ No Re-verf ☐											
Design ☐ Operator ☐											
Doc/Data ☐ Offset/Set ☐											
Equip/Tooling ☐ Supplier ☐											
Handling/Pre ☐ Training ☐											
Material ☐ Use for Tr. ☐											
Internal Transport ☐ Poor Information ☐											
Tribal Knowledge ☐ Rushing ☐											
LOA ☐ Product Improvement ☐											
Substation ☐ Process Improvement ☐											
Past Expiry Date ☐ Manufacturing Process ☐											
Misidentified ☐ Past Due ☐											
OTHER: _____											
Crushing ☐											
Heat Treat ☐											
Wave/Twist in Tube ☐											
Marks/Chatter ☐											
Cut Too Short ☐											
Instructions Incomplete/Unclear ☐											
Drill Holes ☐											
Fit/Function ☐											
Misaligned/off center ☐											
Surge ☐											
am ☐											
ck Pulled ☐											
uence ☐											
Positioned Wrong ☐											
Outside Dimensions ☐											
Over/Under tolerance ☐											
Part Incorrect ☐											
Part Lost/Missing ☐											
Part Moved ☐											
Drawing ☐											
Finish ☐											
Misread ☐											
Turning Sequence ☐											



Container No: 8055551



Part: RBT400313

JOB No: 173853

Serial No/Batch: 8095561

Revision: 1

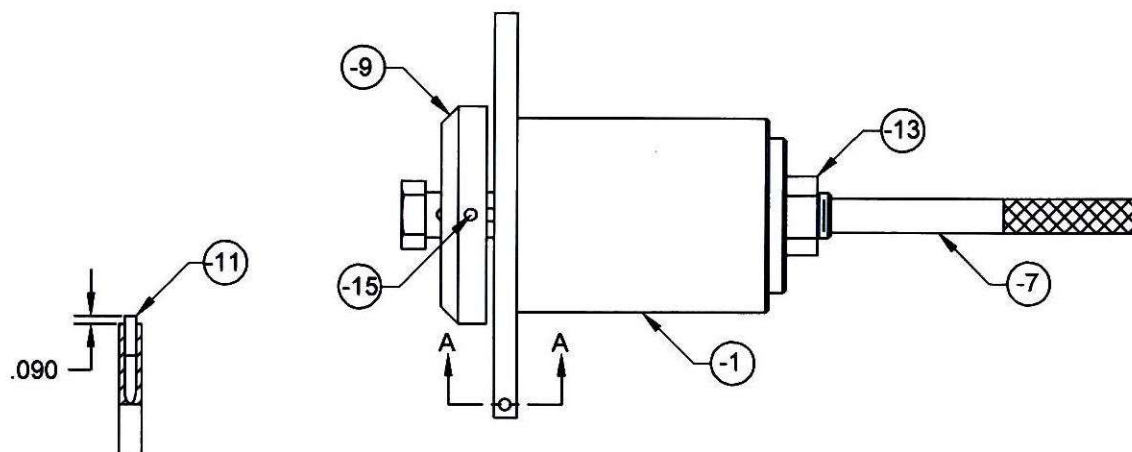
Inspector:

Exp Date:

Instructions:

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D BOM -11 FROM #1/8 x 7/16, ADDED NOTE REF. BELL #. CORRECTED -1 VIEW ADDED MISSING LINES, MOVED NOTE 2 TO -17 & CORRECTED NOTE 1. CORRECTED -3 VIEW ADDED MISSING LINES. CH'D -9 Ø.125 HOLE TO LIMIT DIMENSION. ADDED -17 PLATE ASSEMBLY.	5/16/12	RJC	SE
1	-1 ADDED REF. DIMS AND NOTES. -3 ADDED Ø2.120+0.002-0.000 ±.030 HOLE, CH'D DIMS WAS .250 IS (.250), WAS (.090) IS .090, WAS (Ø.500) IS Ø.500. ADDED SECTION A-A. -5 CH'D DIMS WAS Ø2.118 IS Ø2.118±.002, WAS 2.964 IS 2.994. DELETED -17. CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/12/14	DPD	GE



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173353 MJS
18-02-28

NOTE:
REF. ORIGINAL BELL #212-040-001-19GIF-1.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	ADAPTER WELDMENT			2
1			-3		PLATE	A36 PLATE	1/4 x 3-1/16 x 4-1/2	3
1			-5		ADAPTER	4140 Q&T	Ø2-1/8 x 3-1/8	4
			-7	1	BOLT	STEEL GRD.5	1/2-13 UNC-2A x 8 MCMaster-CARR #91247A740 (MOD.)	5
			-9	1	SHOE	4140 Q&T	Ø2-3/8 x 5/8	6
1	B/O		-11		DOWEL PIN	18-8 S.S.	Ø1/8 x 1/2 MCMaster-CARR #90145A471	1
	B/O		-13	1	HEX NUT	STEEL	1/2-13 UNC-2B MCMaster-CARR #95462A033	1
	B/O		-15	1	ROLL PIN	STEEL	Ø1/8 x 1 MCMaster-CARR #98296A883	1
ASSY	-1							

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400313	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 1-7-11
SHEET 1 of 6	
DRAWN BY: CLOUGH APPROVED: <i>D. Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL BELL 204, 205, 212	